



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3311

Job Sheet 199515



Part No: 646.3311

Job Qty: 16 pcs

Part Name: RH Half - Upper Cutter Assembly

19 pcs. B.A



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/23/19

Description:

Type: Stock

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/27 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	16 pcs		9/23/19	0.59	21.05	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	16 pcs		9/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

DAS
64
9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S224197



Part: 646.3311

Job No: 199515

Serial No/Batch: S224197

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/19/19

Plex 8/27/19 10:26 AM Dart.laje.

					QC 2 - 66	
					QC 2 - 64	mm 2019/10/17
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	16 pcs	9/23/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	SBL 14/10/20
140	Outsource - 4 - Anodize	16 pcs	9/23/19		ATG001-VC	8 2019-10-25
150	Packaging 2-1 - Receive - B4B	16 pcs	9/23/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	10 NOV 2 8 2019
					Packaging 2 - 4 - B4B	NOV 2 8 2019
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155 QC 6	16 pcs	9/23/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	16 pcs	9/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	

Plex 8/27/19 10:26 AM Dart.lajeunesse.marie

					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	16 pcs	9/23/19	0.00	0.00	QC 21 - SA - 21 ✓	9 cck022
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21

Part Op 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB154

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location:) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

JAN 10 2020

41899 Hard Black + Prime

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X7.000	7075-T6S Sheet 2" Thick Plate X 7" Wide (Order In Billets - 17.8400 ft (1.115 ea)	17.8400 ft (1.115 ea)	110-HAAS 4 Axis	521677

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S2.000X7.000	18	6	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	RH Half	7.296inches $\pm$ 0.005	7.301 7.291		
2	RH Half	3.767inches $\pm$ 0.005	3.772 3.762		
3	RH Half	0.457inches $\pm$ 0.005	0.462 0.452		
4	RH Half	0.313inches $\pm$ 0.005	0.318 0.308		
5	RH Half	0.710inches $\pm$ 0.005	0.715 0.705		
6	RH Half	6.469inches $\pm$ 0.005	6.474 6.464		
7	RH Half	10.116inches $\pm$ 0.005	10.121 10.111		
8	RH Half	10.309inches $\pm$ 0.005	10.314 10.304		
9	RH Half	0.177inches $\pm$ 0.005 - 0.001	0.182 0.176	diameter	
10	RH Half	0.209inches $\pm$ 0.005 - 0.001	0.214 0.208	diameter	
11	RH Half	0.250inches $\pm$ 0.005	0.255 0.245		
12	RH Half	1.250inches $\pm$ 0.005	1.255 1.245		
13	RH Half	0.125inches $\pm$ 0.005	0.130 0.120	Radius	
14	RH Half	3.513inches $\pm$ 0.005	3.518 3.508		
15	RH Half	8.375inches $\pm$ 0.005	8.380 8.370		
16	RH Half	0.250inches $\pm$ 0.005	0.255 0.245		
17	RH Half	8.100Degrees $\pm$ 0.500	8.600 7.600	Angle	
18	RH Half	11.689inches $\pm$ 0.005	11.694 11.684		
19	RH Half	11.250inches $\pm$ 0.005	11.255 11.245		
20	RH Half	0.200inches $\pm$ 0.005	0.205 0.195		
21	RH Half	45.000Degrees $\pm$ 0.000	45.000 45.000	Angle	

Plex 8/27/19 10:26 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
		Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																												
		Bending	Misaligned/off center	Folio/Program	Outside Tolerance																												
		Crushing	BOM/Route	Grain Direction	Drawing																												
Cracks	Broken/Damage/Defect	Weld	Finish																														
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																														
Marks/Chatter	Drill Holes	Out of Sequence	Misread																														
Mislabeled	Fit/Function	Off-set/Set-up																															
Completed By _____																																	
Lead hand / Supervisor _____																																	
QC / QA Coordinator _____																																	
		Other/Details: _____																															



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044899**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044899

PO Date: 10/25/19

Due Date: 11/11/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-15

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199515	646.3311	646.3300 Rev A	RH Half - Upper Cutter Assembly : Various STC's Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X19	-	11/11/19	19 pcs	0 pcs	19 pcs	\$19.62/pcs	\$372.78
2	200991	646.3713	646.3700 Rev A	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed X19	-	11/11/19	22 pcs	0 pcs	22 pcs	\$17.27/pcs	\$379.94
3	200993	646.3714	646.3700 Rev A	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	-	11/11/19	20 pcs	0 pcs	20 pcs	\$17.27/pcs	\$345.40

Dec 40 9-89

NOV 28 2019
NOV 28 2019

NOV 28 2019



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044899



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199514	646.3310	646.3300 Rev A	LH Half - Upper Cutter Assembly : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed X21	-	11/11/19	21 pcs	0 pcs	21 pcs	\$19.62/pcs	\$412.02
											NOV 28 2019	
Grand Total:												\$1,510.14

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 11/15/19 10:01 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919033

Date: 27-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
19 ea	Part: 646.3311 RH Half Upper Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - 9mils) per drawing. Batch/Lot# 120908 Job: 26342 PO: POHB044899	Rev: A	atg
21 ea	Part: 646.3310 LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - 9mils) per drawing. Batch/Lot# 120908 Job: 26345 PO: POHB044899	Rev: A	atg
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: NOV 27 2019 Certified Signature: Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

DAS
40
9-89

RECEIVED
NOV 27 2019
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919033

Date: 27-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			